

Date: Monday, 9/11/2006 3:45:25 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG
 Job Number : 28489
 Estimate Number : 10337
 P.O. Number : N/A
 This Issue : 9/11/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 27563
 Written By : [Signature]
 Checked & Approved By : [Signature] 06 09.12
 Comment : Est A 05.06.02 New Issue KJ/JLM

Part Number : D28073
 Drawing Number : D2807 REV C
 Project Number : N/A
 Drawing Revision : C
 Material : HA
 Due Date : 9/30/2006 Qty: 80 Um: 78 Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M303R0750 303 Round Bar .75"



Comment: Qty.: 0.1094 f(s)/Unit Total : 4.3764 f(s) 8.76
 Material: 303 Round Bar Ø0.750"
 (M303R0.750) Batch: M102318

J.G 06/10/24

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE
 Turn as per Folio FA529 and Dwg D2807 Dwg Rev: C
 2-Deburr

J.G 06/10/25
 06/10/24

(78)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.G 06/10/24

(78)

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: Haas #1
 Machine as per Folio FA528 and Dwg D2807 Dwg Rev: C
 Folio Rev: C

2-Deburr

J.F. 06/11/05

(78)

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/11/05

(78)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 20/11/07

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/11/2006 3:45:25 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 28489

Part Number: D28073

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SD 06/11/06

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57387

06/11/06 (78)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/07

Job Completion



06/11/07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

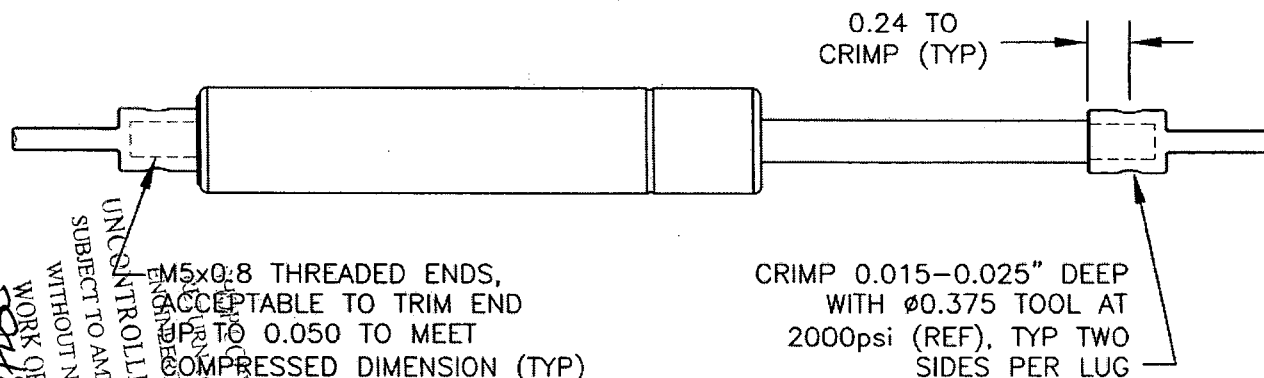
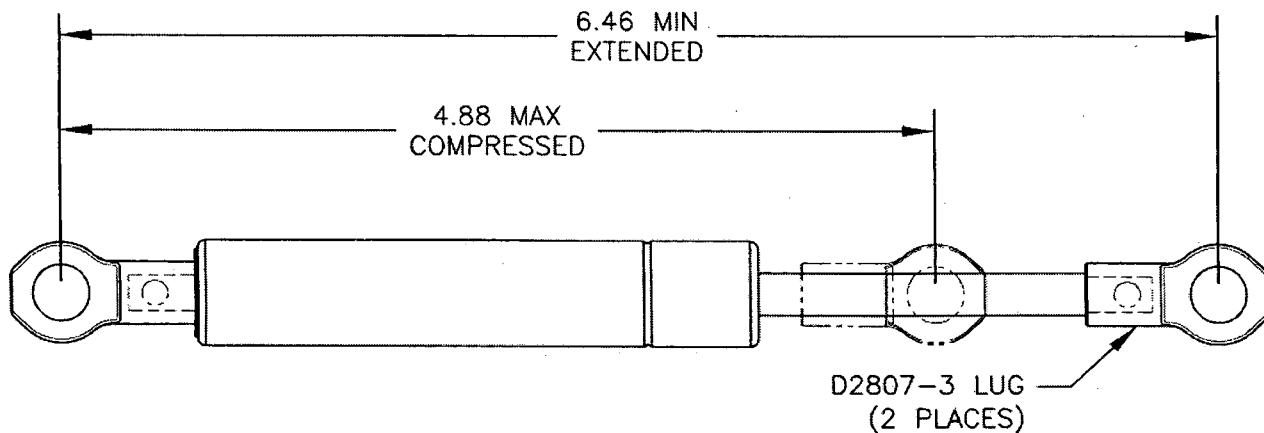
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
#05-06-16

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		
DATE	05.05.25	TITLE	D2807	REV. C
			GAS SPRING	SHEET 1 OF 2
A	00.11.03		NEW ISSUE	SCALE
B	05.03.16		ADD FINISH	1:1
C	05.05.25		CHANGE SPRING TO SS, ADD -3 LUG	



M5x0.8 THREADED ENDS,
ACCEPTABLE TO TRIM END
UP TO 0.050 TO MEET
COMPRESSED DIMENSION (TYP)

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 28487

D2807 GAS SPRING

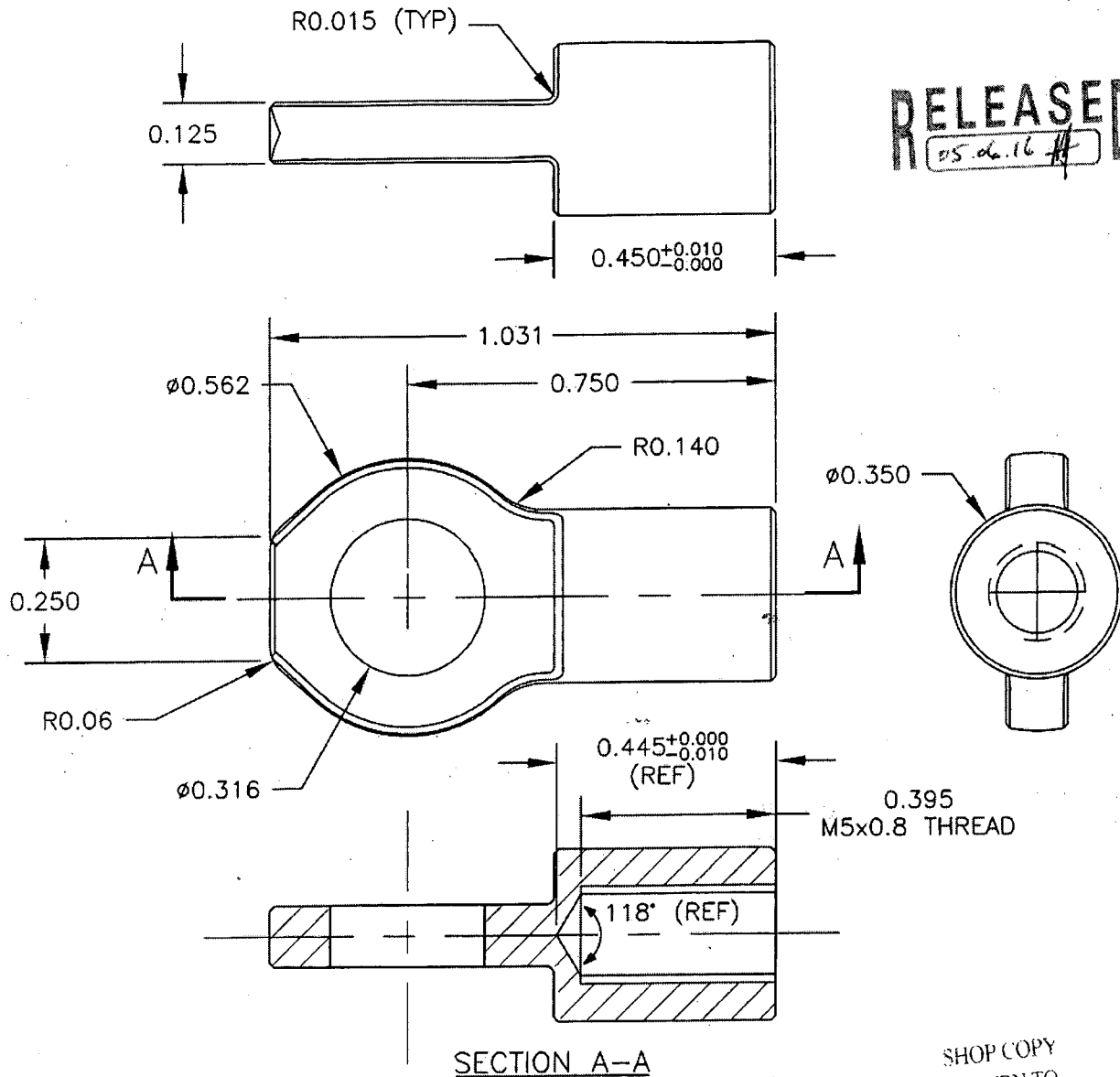
- 1) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 lb MIN TO 45 lb MAX
M5x0.8 THREADS

POSSIBLE SUPPLIER: ArvinMeritor Motion Control Systems, Leicester, UK
P/N: SXF6S6050080S6L-115N
(REF: 80mm LONG CYLINDER, 50mm STROKE, 115N LOAD)

- 3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2807	REV. C SHEET 2 OF 2
DATE 05.05.25	TITLE GAS SPRING		SCALE 3:1

**RELEASED**
05.06.16 [Signature]**D2807-3 LUG**

- 1) MATERIAL: AISI 303 ROUND BAR (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.015
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
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WORK ORDER
NO. 28489

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